

Date Opened: **15 September 2013**

Job #: **940**
Project: **Ski Basket**
Type: **AS350/AS355**

Approval: **SH08-16**
Drawing List: **DCL940-3, Rev. 0**

<u>Fabrication and Assembly Drawing(s)</u>	<u>Description</u>
94010, Rev. 0	Basket Ass'y
94011, Rev. 0	Basket Body Ass'y
94012, Rev. 0	Basket Lid Ass'y
94023, Rev. 0	Attachment Hoop
94030, Rev. 0	Hoop
84255, Rev. 1	Handle Installation
84261, Rev. 1	Handle Bar Ass'y
84262, Rev. 1	Handle Bracket Ass'y
70405, Rev. 3	Lid Step Modification

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y</u>
Drawings revision levels match Document Control List:	<u>Y</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y</u>
Release tags associated with all fabricated parts are attached:	<u>Y</u>
All mounting hardware and supplies are included:	<u>Y</u>

List all non-conformities raised: _____

Inspector Signature: _____

Date: _____

Drawing: **94010** **Revision 0**
 Assembly: **94010-01** **Cargo Basket Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	94010-01	Cargo Basket Assembly			
. 1	94011-01	Basket Body Assembly	Below		
. 1	94012-01	Basket Lid Assembly	Below		
. 1	84255-01	Handle Bar Installation	Below		
. 1	36280-01	Brace Assembly	9-2081 Brace	12059	
. 1	MS20001P4	Piano Hinge		12066	
. 1	94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	11102	
. 4	49205-14	Bumper	Argus Industries Bumper	11010	
. A/R	CR3213-5-02	Cherry Rivet		12055	
. 8	CR3523-5-02	Cherry Rivet		12087	
. 4	CR3213-4-02	Cherry Rivet		12032	
. 4	96710-01	Fitting	Alternate to Ancra 40088-14	WO2012-44	
. 8	NAS1149FO663P	Washer		12052	
. 1	AN3-15A	Bolt		12052	
. 1	AN3-17A	Bolt		12052	
. 3	NAS1149FO363P	Washer		12067	
. 2	AN970-3	Washer		12032	
. 2	MS21044N3	Nut		12032	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR Rivets		
Final Inspection	Drawing 94010			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **94011** Revision **0**
 Assembly: **94011-01** **Basket Body Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	94011-01	Basket Body Assembly			
. A/R	--	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	12123	
. A/R	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	12123	
. 4	94030-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	12123	
. 2	94023-01	Attachment Hoop			
. . 1	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	12123	
. . 1	--	Tube	4130 Steel, 1.0" x 0.065 Sqr. Tube	12045	
. . 1	94023-05	Stud	1018 Mild Steel, 5/8" Dia.	12056	
. . 1	94023-07	Stud	1018 Mild Steel, 5/8" Dia.	12056	
. . 1	76423-04	Cap	1018 Mild Steel, 0.050" Sheet	9010	
. 1	84262-01	Handle Bracket Assembly	Below		
. 1	49215-01	Spacer	1018 Steel, 1/2" Rod	12056	
. A/R	3/4-16F	Mesh	Expanded carbon steel	12130	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 94011			
Final Inspection	Drawing 94011			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **94012** **Revision 0**
Assembly: **94012-01** **Basket Lid Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	94012-01	Basket Lid Assembly			
. A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	12123	
. 1	49216-01	Spacer	1018 Steel, 1/2" Rod	12056	
. 1	84262-01	Upper Handle Bracket Assembly	Below		
. 1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
. A/R	3/4-16F	Mesh	Expanded carbon steel	12065	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 94012			
Final Inspection	Drawing 94012			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **84255** **Revision 1**
Assembly: **84255-01** **Handle Installation**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	84255-01	Handle Installation			
. 1	84261-01	Handle Bar Assembly	Below		
. 2	84267-01	Bracket	Delrin, 3/4" Sheet	WO2012-36	
. 2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	12033	
. 2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	11030	
. 2	AN3-12A	Bolt		13017	
. 4	AN3-11A	Bolt		13017	
. 12	AN960-10	Washer		12132	
. 6	MS21044N3	Nut		12132	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **84261** **Revision 1**
Assembly: **84261-01** **Handle Bar Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	84261-01	Handle Bar Assembly			
. 1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.065 Rnd. Tube	12093	
. 2	84265-01	Lever	304 Stainless, 0.105 Sheet	10036	
. 2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	11057	
. 2	MS20615-4M3	Rivet		7039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **84262** **Revision 1**
Assembly: **84262-01** **Handle Bracket Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	84261-01	Handle Bracket Assembly			
. 4	84272-01	Bushing	4130 Steel, 5/16" x 0.058 tube	11049	
. 4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
. 2	36275-02	Support	304 Stainless, 5/16" Rod	11093	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **70405** **Revision 3**
Assembly: **70405-01** **Lid Step Modification**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	70405-01	Lid Step Modification			
. 10	70405-03	Tube	4130 Steel, ½" x 0.035 Sqr. Tube	12123	
. 1	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	12118	
. A/R	CR3213-4-2	Cherry Rivet		12032	

Note: Step is installed on all bays of lid.

Note: Remainder of assembly listed on drawing 94012

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Basket Handle No. of pieces: 1

Manufacturer: AERO Design

Part No.: 84255-01 Serial / W.O. No.: _____

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-41

Remaining Tasks to be Performed: Install onto Basket

Signature: [Signature]

Date: Sept 2012/2013 Lic. No. / ACA ADO3

Serviceable



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AMF 73-04

Remarks

Serviceable

Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: A5350 Lcd (SK1)

Manufacturer: AERO Design

Part No.: 94012-01 Serial / Batch No.: _____

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-41

Remaining Tasks to be Performed: Wekls Cleaned, Mesh
tightened

Signature: Chris Small

Date: Nov 27 2013 Lic. No. / ACA A1D03

In Process



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AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: A-350 XL Ski Basket No. of pieces: 1

Manufacturer: AERO Design

Part No.: 94010-01 Serial / W.O. No.: 94001-31

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-41

Remaining Tasks to be Performed: None

Signature: Curtis

Date: Oct 31 2013 Lic. No. / ACA AD03

Serviceable



Aero Design Ltd.

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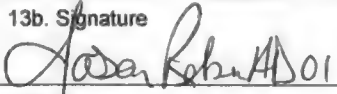
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04


Remarks

Lid prop to Be mounted on Left or
Right Side


Serviceable

1. Approving Civil Aviation Authority/Country Transport Canada		AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-41	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cargo Basket	94010-01	1	94001-29	New	
12. Remarks Modified with walkway on lid IAW DCL704, Black						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jason Rekve – AD01		13e. Date (dd/mm/yyyy) 25 Sep 2013		14d. Name		14e. Date (dd/mm/yyyy)
Installer Responsibilities						
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						

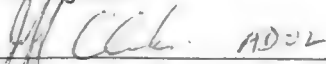
SILVERSTAR

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-41
6. Item	7. Description Cargo Basket	8. Part Number 94010-01	9. Qty. 1	10. Serial/Batch No. 94001-31	11. Status/Work New
12. Remarks Modified with walkway on lid IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 12 Dec 2013		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

KOO TENAY VALLEY

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-41
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	94010-01	1	94001-31	New
12. Remarks Modified with walkway on lid IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 27 Jan 2014		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

HGA T2212A12

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-41	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cargo Basket	94010-01	1	94001-33	New	
12. Remarks Modified with walkway on lid IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 01 May 2014		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

SUMMIT

• **CARGO BASKET ASSEMBLY - COMMON**

2014-41

407 Ht 11 ft x 1

• **General**

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

→ 76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

→ 70405, Revision 3? – Lid Walkway

→ 70403, Rev 5 – Aux Latch

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2014-41

Date Open: 14 APR 2014

APR 14

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

APR 14

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

A001

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90" ✓
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

AD004

- a. Install handle brackets.
- Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - Torque AN3 bolts to ??.
- b. Install handle
- Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - Grease two 36275-01 bushings with ?? . Insert into bushings of handle assembly.
 - Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - At first end, remove bolt and repeat step iv.
 - Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - Torque AN3 bolts to ??.
- c. Check handle
- Operate handle to ensure handle does not bind and springs hold handle in.
 - Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

AD016

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #) _____

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2014-41

Material Tracking Sheet

1 of 2

Bell 206L / 407

Date Opened: 14 APR 2014

High Mounted Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		76610-01	Cargo Basket Assembly		
Step 1				<i>Lid Assembly</i>		
	. 1		60632-01	Basket Lid Assembly		
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	<u>11010</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		76627-01	Placard	0.063 Sheet, 6061-T6 Aluminum	<u>S/N 76601-17</u>
	. . 4		CR3213-4-02	Cherry Rivet		
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>13066</u>
	. . A/R		CR3213-4-02	Cherry Rivet		<u>14032</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	<u>✓</u>
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		76611-01	Basket Body Assembly		
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	<u>13042</u>
	. . 8		NAS1149F0663P	Washer		<u>13035</u>
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	<u>13089</u>
	. 8		CR3523-5-02	Cherry Rivet		<u>12087</u>
	. A/R		CR3213-5-02	Cherry Rivet		<u>13026</u>
Step 4	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>203-32</u>
	. . 4		AN3-11A	Bolt		<u>14001</u>
	. . 8		NAS1149F0363P	Washer		<u>13084</u>
	. . 4		MS21044N3	Nut		<u>13083</u>

Work Order: 2014-41Material Tracking Sheet
Bell 206L / 407
High Mounted Basket Assembly

2 of 2

Date Opened: 14 APR 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly	2014-25	
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	13085
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	36275-01
	.. 2		AN3-12A	Bolt		
	.. 4		NAS1149F0363P	Washer	13084	
	.. 2		MS21044N3	Nut	13083	
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly	2014-29	
	. 1		AN3-15A	Bolt	13084	
	. 1		AN3-17A	Bolt	13084	
	. 2		AN970-3	Washer	13012 094 ne	
	. 3		NAS1149F0363P	Washer	13084	
	. 2		MS21044N3	Nut	13083	
Step 6				Inspection	None	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 94001-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"300 LBS/136 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES

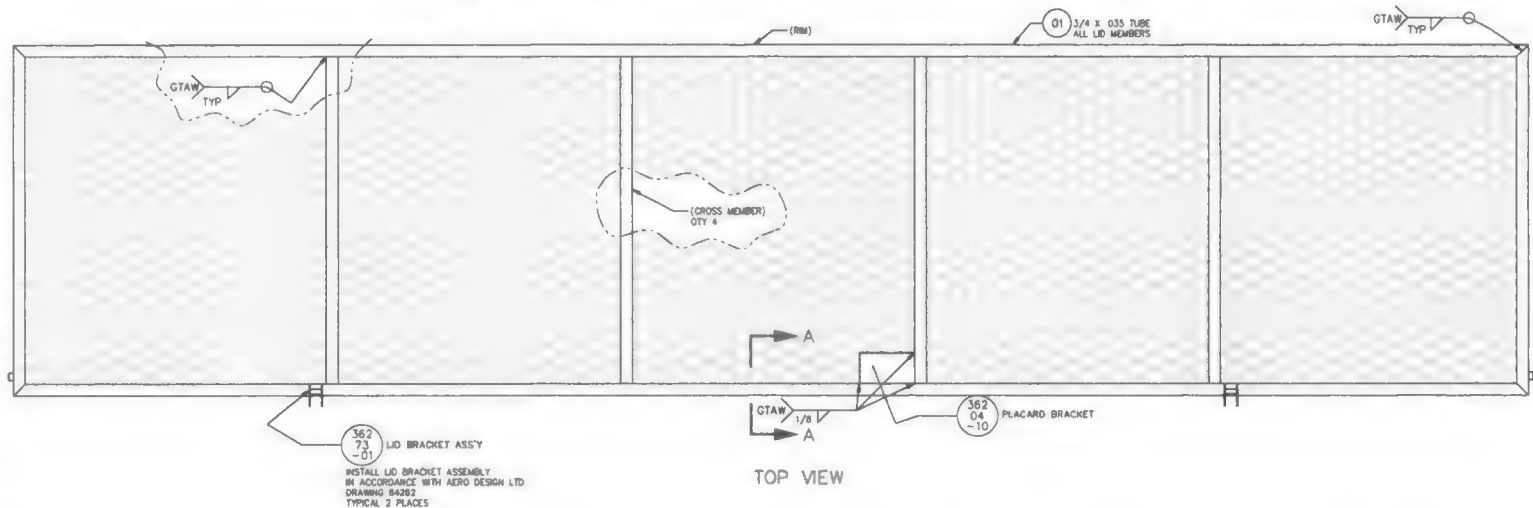


01 PLACARD

94027-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.	APPROVALS		DATE		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca				
	DRAWN: R. RATHWELL		OCT 3, 2011						
	CHECKED: E. BURGAIN				EUROCOPTER AS350 & AS355 SERIES LARGE QUICK RELEASE CARGO BASKET PLACARD				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1								
		SCALE 1 : 1		DWG. SIZE A1		DWG. NO. 94027		REV. 0	
		SHEET 1 OF 1							



SECTION A-A

SCALE 1:2

DRILL 1/2" THROUGH OUTBOARD SIDE OF TUBE
INSERT SPACER FULLY AND WELD IN PLACE
DRILL NO. 9 (0.196) THROUGH AFTER WELDING
TYPICAL BOTH ENDS

END VIEW

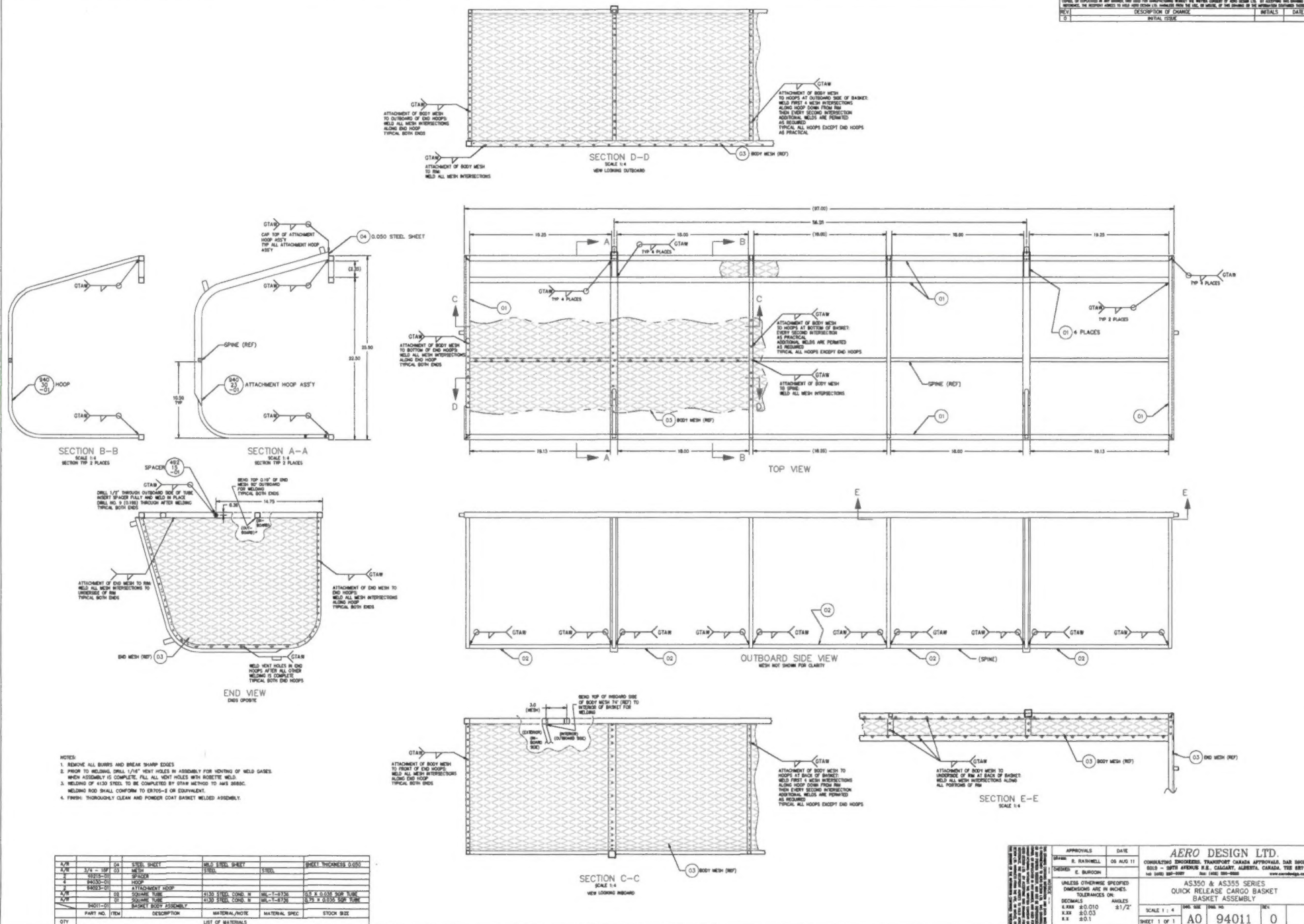
1	36204-10		PLACARD BRACKET				
2	36275-10		LID BRACKET ASSY				
	49218-01		SPACER				
A/R	3/4 x 16F	02	MESH	STEEL	STEEL		
A/R		01	SQUARE TUBE	4130 STEEL COND N	MIL - T-6736	0.75 X 0.035 SOR TUBE	
	94012-01		LID ASSEMBLY				
	PART NO.	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE	
QTY				LIST OF MATERIALS			

NOTES

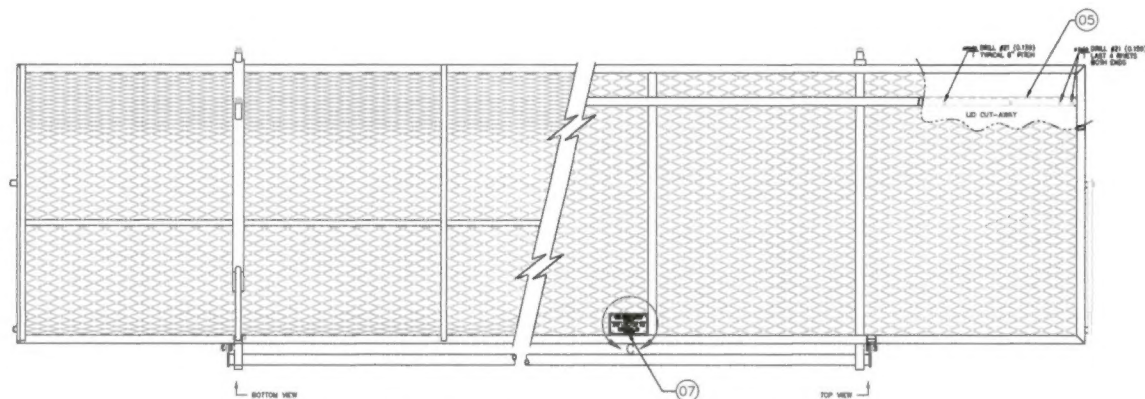
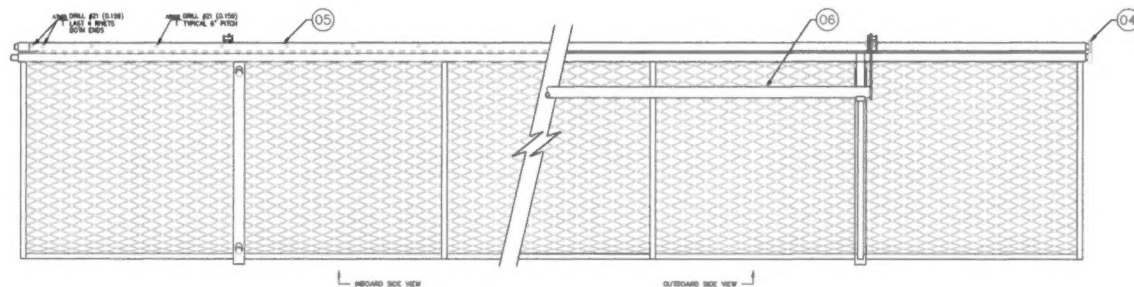
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL 1/16" VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 268SC. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
4. FINISH: THOROUGHLY CLEAN AND POWDER COAT LD WELDED ASSEMBLY

APPROVALS _____ DATE _____ DRAWN BY RATHWELL 05 AUG 11 CHECKED E BURGION		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 2004 2015 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 0M7 Tel: (403) 242-2877 Fax: (403) 242-2878 www.aerodesignltd.com	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON _____ DECIMALS _____ ANGLES _____ X.XX ±0.010 ±1/2" XX ±0.03 X.X ±0.1		AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET LID ASSEMBLY	
SCALE 1 OF 1 SHEET 1 OF 1		DWG. SIZE A1	DWG. NO. 0

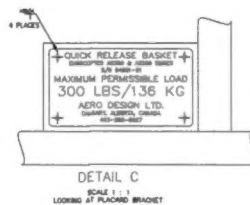
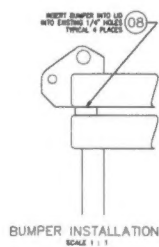
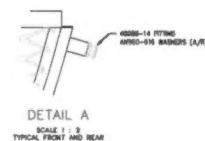
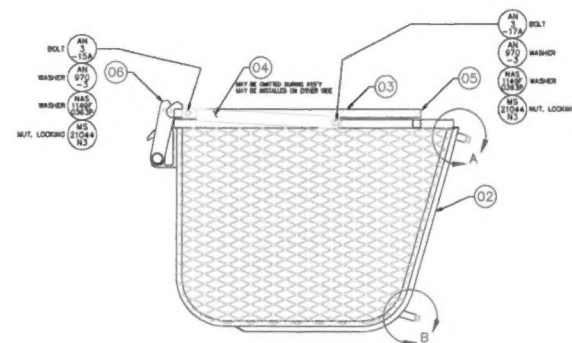
REVISION	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INITIAL ISSUE		



REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INITIAL ISSUE		



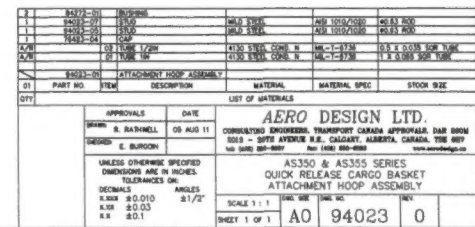
94010-01 CARGO BASKET ASSEMBLY - RH



NOTE:
1. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	00100-01	01	WASHER			
1	00100-02	02	WASHER			
1	00100-03	03	WASHER			
1	00100-04	04	WASHER			
1	00100-05	05	WASHER			
1	00100-06	06	WASHER			
1	00100-07	07	WASHER			
1	00100-08	08	WASHER			
1	00100-09	09	WASHER			
1	00100-10	10	WASHER			
1	00100-11	11	WASHER			
1	00100-12	12	WASHER			
1	00100-13	13	WASHER			
1	00100-14	14	WASHER			
1	00100-15	15	WASHER			
1	00100-16	16	WASHER			
1	00100-17	17	WASHER			
1	00100-18	18	WASHER			
1	00100-19	19	WASHER			
1	00100-20	20	WASHER			
1	00100-21	21	WASHER			
1	00100-22	22	WASHER			
1	00100-23	23	WASHER			
1	00100-24	24	WASHER			
1	00100-25	25	WASHER			
1	00100-26	26	WASHER			
1	00100-27	27	WASHER			
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1	00100-38	38	WASHER			
1	00100-39	39	WASHER			
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1	00100-49	49	WASHER			
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1	00100-74	74	WASHER			
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1	00100-79	79	WASHER			
1	00100-80	80	WASHER			
1	00100-81	81	WASHER			
1	00100-82	82	WASHER			
1	00100-83	83	WASHER			
1	00100-84	84	WASHER			
1	00100-85	85	WASHER			
1	00100-86	86	WASHER			
1	00100-87	87	WASHER			
1	00100-88	88	WASHER			
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1	00100-92	92	WASHER			
1	00100-93	93	WASHER			
1	00100-94	94	WASHER			
1	00100-95	95	WASHER			
1	00100-96	96	WASHER			
1	00100-97	97	WASHER			
1	00100-98	98	WASHER			
1	00100-99	99	WASHER			
1	00100-100	100	WASHER			

PART		APPROVALS		DATE	LIST OF MATERIALS
BASIC CODE REV. NO. 001	ISSUED FOR ISS				





WO# 2013-41

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013